

Date: Thursday, 29/03/2007 1:11:14 PM  
User: Linda Lacelle

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 31537  
**Estimate Number** : 12156  
**P.O. Number** : N/A  
**This Issue** : 29/03/2007  
**Prsht Rev.** : NC  
**First Issue** : N/A  
**Previous Run** : 31257  
**Written By** :  
**Checked & Approved By** :  
**Comment** :  
est rev. A 06.02.02 new issue EC  
est rev. B 06.03.29 added alodine EC

**Drawing Name** : HEAT OUTLET DEFLECTOR  
**Part Number** : D34725  
**Drawing Number** : D3472 REV.A  
**Project Number** : N/A  
**Drawing Revision** : A  
**Material** : N/A  
**Due Date** : 05/04/2007  
**Qty**: 2 **Um**: Each

**Type** : PURCHASED PARTS

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 M2024T3S063 2024-T3 .063 sheet



**Comment:** Qty.: 1.1428 sf(s)/Unit Total: 2.2856 sf(s)

2024-T3 .063 sheet

Batch: M103321

ml 07 03 30

(2)

2.0 WATER JET FLOW WATER JET



**Comment:** FLOW WATER JET

Cut as per Dwg D3471

Dwg Rev: A

Prog Rev: A

ml 07 03 30

(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 30

(2)

4.0 QC8 SECOND CHECK



**Comment:** SECOND CHECK

ml 07 03 30

2

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2- Buff out scratches

ml 07 03 30

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 07/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAT OUTLET DEFLECTOR

Job Number: 31537

Part Number: D34725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD

07/03/30 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/30 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/3/30 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/30 (2)

Job Completion



07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

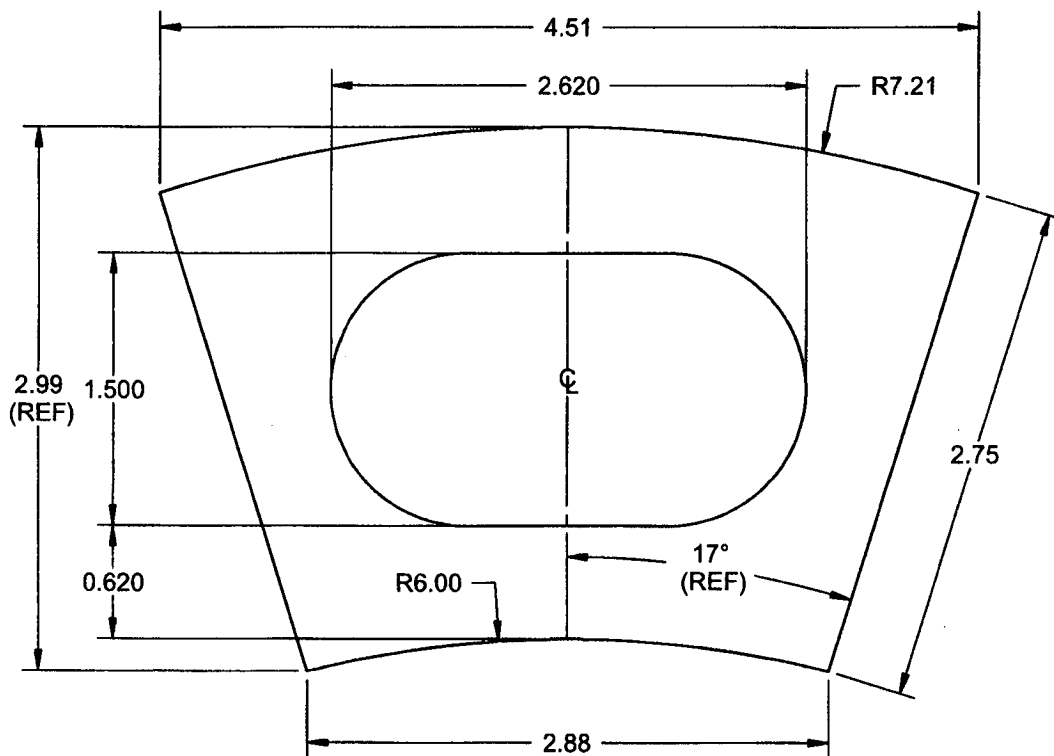
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3472</b>	REV. A SHEET 4 OF 4
DATE <b>06.01.17</b>		TITLE <b>HEAT OUTLET DEFLECTOR</b>	SCALE 1:1

06-04-03 *[Signature]*



### **D3472-5 FLAT DOUBLER**

#### **NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING  
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31537
<b>Description:</b> Heat outlet Deflector		<b>Part Number:</b> D3472-5
<b>Inspection Dwg:</b> D3472 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.99	+1-0.030	2.99	✓		VERN	
B	4.51	+1-0.030	4.508	✓		VERN	
C	2.620	+1-0.010	2.620	✓		VERN	
D	1.500	+1-0.010	1.497	✓		VERN	
E	0.620	+1-0.010	0.625	✓		VERN	
F	2.88	+1-0.030	2.88	✓		VERN	
G	2.75	+1-0.030	2.75	✓		VERN	
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> ML ML	<b>Audited by:</b> MB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07 03 30	<b>Date:</b> 07/03/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
		new Issue	KJ/RF	